

Work Order ID 80804

80804

Page 1

February-29-12 11:44:07 AM

Item ID: D4571-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Base

Start Date: 29/02/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/02/29 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4571

B

100

Cut blanks as per folio

0.00

100

Bandsaw

Jeaspa Bandsaw

Memo

CUT TO 7.250" LONG

0.00

SL 12/03/13

5

105

0.00

105

HAAS 1

HAAS CNC vertical machine #1

Hardinge CNC LATHE SMALL

Memo

MACHINE AS PER FOLIO FB080 AND DWG D4471

FOLIO REV: AA

DWG REV: B

0.00

PO/PA 12/03/21

5 1

PTO

DEBURR

W/O: 80804		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4571-1 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: Ad Date: 12/04/04
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ck Date: 12/4/17

NCR: 12-1303		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/03/21	105	TAP HOLE DIST 0,443 ± 0,010 ACT: 0,533	CP 12.03.21 CS/042	SCRAP. Won't assemble correctly with hinge	12/03/21 PD		CP 12.03.21 CS/042	12/03/09
12/03/21	105	TAP hole too far from the edge center drill feed is too high Too much pressure ON the PART -	↓	↓	12/03/21 PD	↓	↓	12/03/09

NOTE: Date & initial all entries

Work Order ID 80804

February-29-12 11:44:07 AM

80804

Page 2

Item ID: D4571-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Base

Start Date: 29/02/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 5.00

5

Customer:

Reference: .

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

12/03/21

12/03/23

5 123-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80804

80804

Page 3

February-29-12 11:44:07 AM

Item ID: D4571-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Base

Start Date: 29/02/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start *NR1*

QC: Date:

SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140 Fire Red(Ref:4.3.5.10) per QSI005 4.3

0.00

140

Powdercoat

Memo

0.00

Powder Coating

START TIME:

7h30

OVEN TEMPERATURE:

m113645

8h00 FINISH TIME:

320°F

5 2 (AP) 12/03/29

145

PTO - D

150 Identify as per dwg & Stock Location GA

0.00

150

Packaging

Memo

0.00

Packaging

SB 12/03/29

(5)

160 QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/3/29

12-03-29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
12/03/28	#145	PERMANENT CHANGE. ADD SEQUENCE FOR QC3	BL G	12-3-28 12-03-29			S 12/03/28	
12/03/28	#145	QC3 inspect	BL G	12-3-28 12-03-29			S 12/03/28	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-29-12 11:44:11 AM

Page 1

Work Order ID: 80804

80804

Parent Item: D4571-1

D4571-1

Parent Item Name: Base

Start Date: 29/02/2012

Required Date: 14/03/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 11-12-21 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.50 0		Purchased	No				f	78.2500		3.210526			

M6061T6B1 500X02 500

6061-T6 Bar 1.50 x 2.50

Location

Loc Qty

Loc Code

MAT004

78.25

103069

12

107387

30.25

16742

36

22 12/03/13
PO 12/03/21

*3.3 + 0.66

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

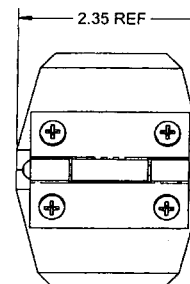
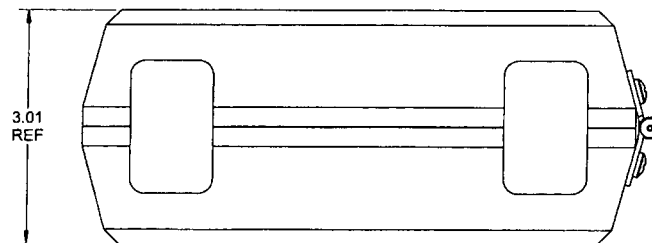
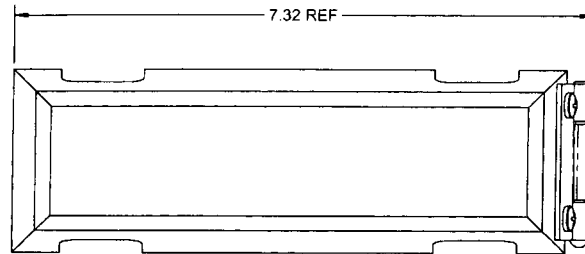
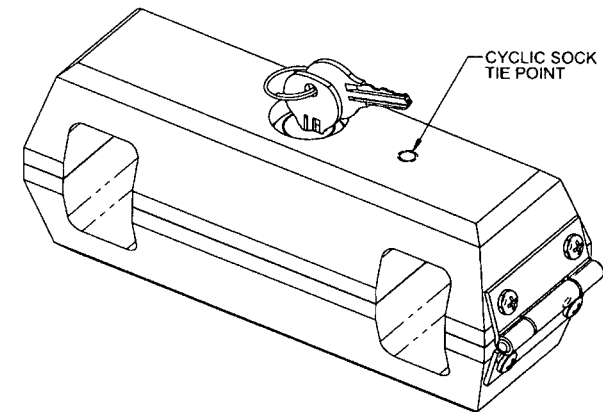
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -051	P/N	DESCRIPTION
	X		D4571-041	TAIL ROTOR DISABLING KIT
	1	X	D4571-051	PEDAL LOCK
	1		D3384-047	CYCLIC SOCK
	1		MS 16995-47	SCREW, SKT-HD
	2		AN960-416	WASHER, FLAT
1		1	D3373-5	CAM LOCK ASSEMBLY
2		1	D3385-3	HINGE
3		1	D4571-1	BASE
4		1	D4571-3	COVER
5		4	MS51957-41	PH-HD SCREW, #8
6		2	97395A461	DOWEL PIN (MCMASTER CARR)

80804 MCT
12/02/29



D4571-051 PEDAL LOCK

RELEASED
R 2012 -01- 30
MD

B	ADDED CYCLIC SOCK AND RELATED HARDWARE TO BOM ADDED DIM 0.560, DELETED DIM 0.188 SHT 3 ADDED DIM 1.200, DELETED DIM 0.300 SHT 4	RP	12.01.23
A	NEW ISSUE	RP	12.01.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	RP	D4571	SHEET 1 OF 4
APPROVED	RP	TITLE	SCALE
DE APPR.	N/A	PEDAL LOCK	NTS
DATE	12.01.23	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

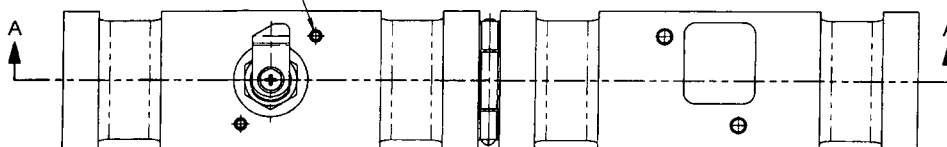
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80804

97395A461
DOWEL PIN (MCMaster CARR)



D4571-3
COVER

D4571-1
BASE

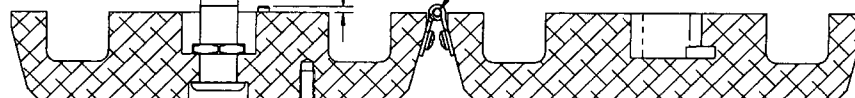
D4571-051 PEDAL LOCK ASSEMBLY

D3373-5
CAM LOCK ASSEMBLY
PEDAL LOCK

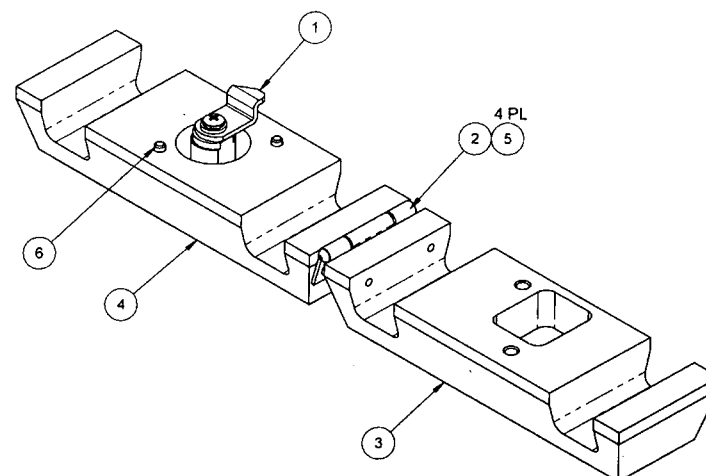
#10 LOCK WASHER REF
#10-32 PN -HD SCREW REF
(AS PER D3373-5)

0.10 TYP
REF

D3385-3
HINGE



SECTION A-A



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.75 lbs

RELEASED
2012-01-30

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	MP	DRAWING NO. D4571	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	PEDAL LOCK	NTS
DATE	12.01.23	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

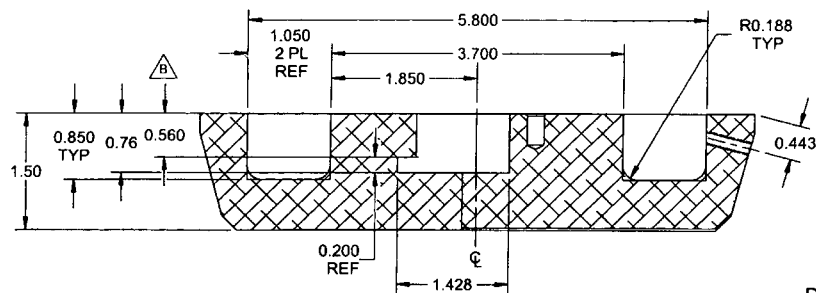
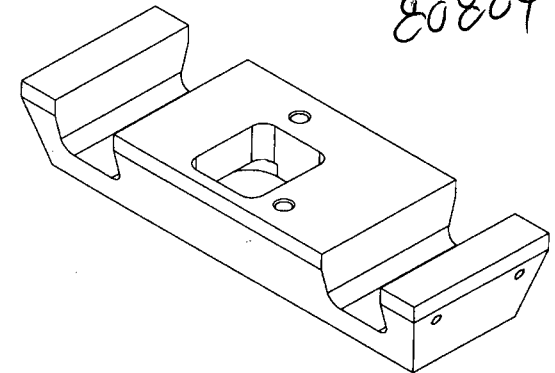
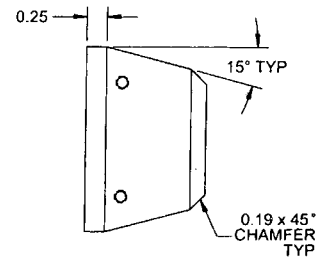
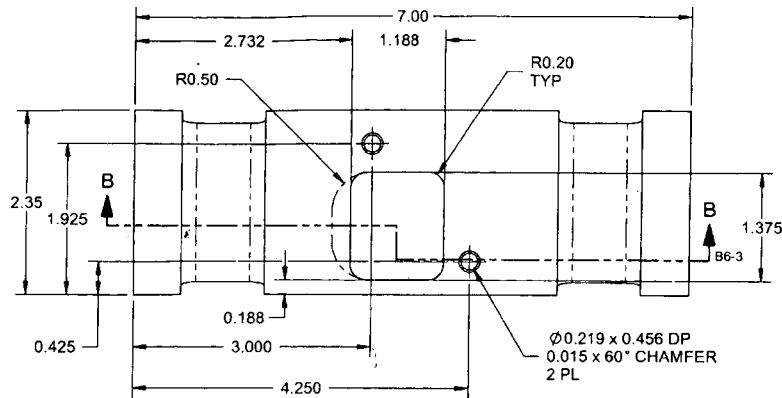
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

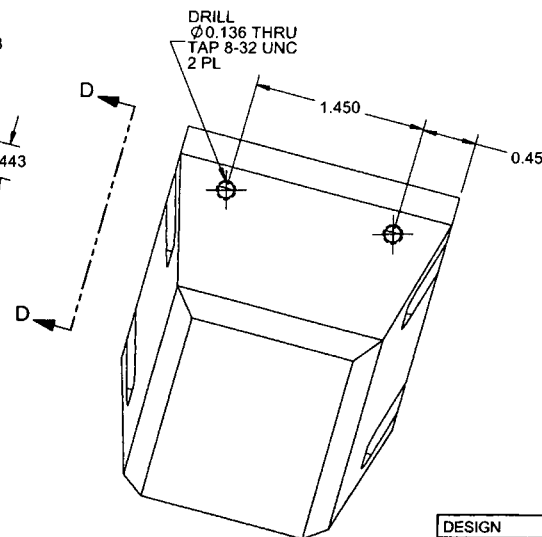
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION B-B C6-3



VIEW D-D

D4571-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221
REF: DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) MASK INSIDE HOLES PRIOR TO FINISH

RELEASED
2012-01-30

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	B	D4571	SHEET 3 OF 4
APPROVED	IND	TITLE	SCALE
DE APPR.	N/A	PEDAL LOCK	NTS
DATE	12.01.23	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

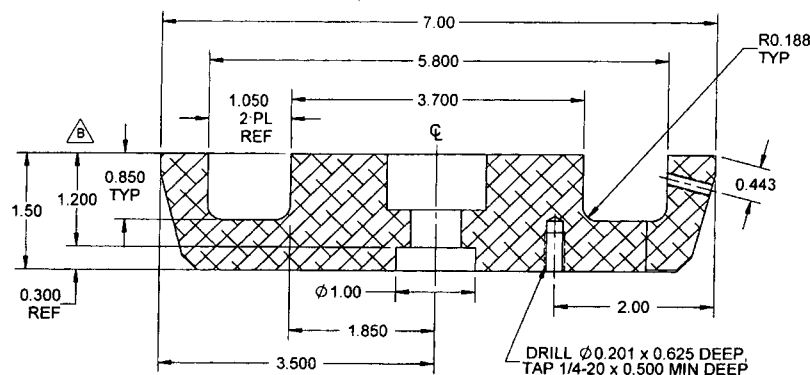
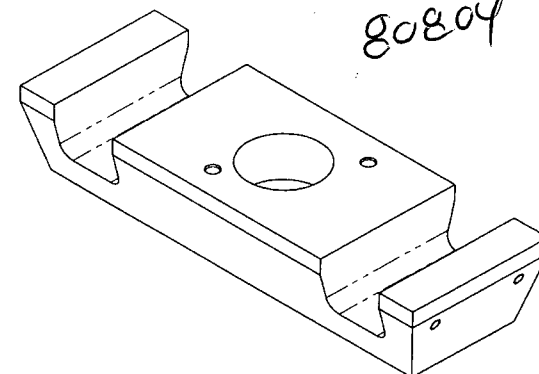
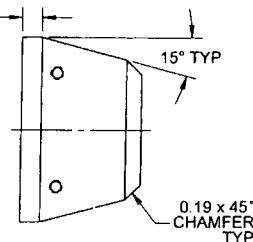
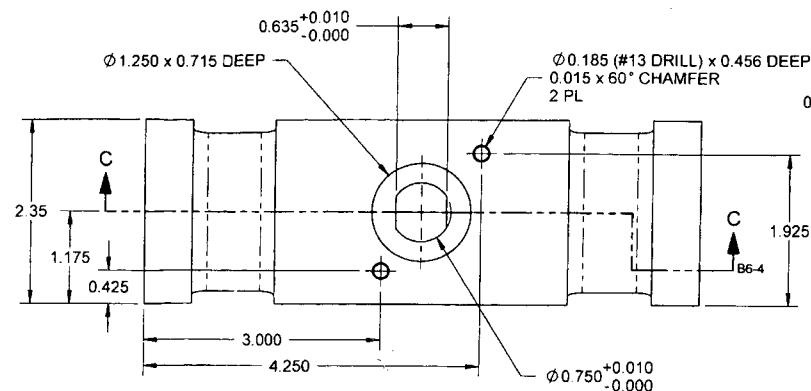
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

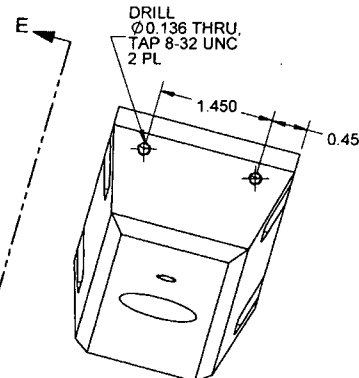
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION C-C D6-4





VIEW E-E

NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF: DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) MASK INSIDE HOLES PRIOR TO FINISH

D4571-3 COVER

RELEASED
2012-01-30

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.		D4571	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.	N/A	PEDAL LOCK	NTS
DATE	12.01.23	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 80804
Description: PEDAL LOCK		Part Number: D4571-1
Inspection Dwg: D4571	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.00 ± 0.030	± 0.030	7.005	✓		Height gage	
1.188	± 0.010	1.187	✓		VERN	GA-09
R0.200	± 0.010	0.200	✓		Rad G	
2.732	± 0.010	2.732	✓		VERN	GA-09
2.350	± 0.030	2.350	✓		"	"
1.925	± 0.010	1.923	✓		"	"
0.425	± 0.010	0.425	✓		"	"
0.188	± 0.010	0.190	✓		"	"
3.000	± 0.010	2.999	✓		"	"
4.250	± 0.010	4.250	✓		"	"
Ø 0.219	+0.005 -0.001	0.220	✓		PIN G	
0.456	± 0.010	0.466	✓			GA-08
1.375	± 0.010	1.375	✓		VERN	GA-09
5.800	± 0.010	5.779	✓		"	"
3.700	± 0.010	3.700	✓		"	"
1.850	± 0.010					
1.050	± 0.010	1.050	✓		VERN	GA-09
0.760	± 0.010	0.764	✓			GA-08
1.50	± 0.030	1.505	✓		VERN	GA-09
Ø 0.443						
0.560	± 0.010	0.557	✓		Height G.	
0.443	± 0.010	0.450	✓		VERN	GA-09
1.428	± 0.010	1.435	✓		VERN	GA-09

Measured by: PO/	Audited by: SRR	Preliminary Approval:
Date: 12-03-21	Date: 12/03/23	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15